

48

6.37

DART AEROSPACE LTD	Work Order:	19895
Description: Bearpaw Kit (13" x 16")	Part Number:	K10005
Dwg: D2671 Rev. B1	Qty:	1 Kits
Ref: K10005 Rev. A		Page 1 of 1

Step	Location	Procedure	By	Date	Qty																																																
1	DC	Issue Traveler Note: (1) K10005 Kit consists of Qty (2) D2671 Dwg not required	HJ	03.11.06	1																																																
2	DC	Photocopy bluefile: K10005 D206-559-021 D500-572-021 and create labels per PPP K10005 CHG002 WK 46 HJ (Bag Bluefiles separately)	HJ	03.11.13	1																																																
3	GA	Cut 2 blanks per (1) K10005 Kit Cut blank: 13.00" x 16.00" x 1.00" thick Material: Black UHMW 1" (MUHMWB10) Batch: 11711 M13307 P11	RG	04.01.08	1																																																
4	MV	Inspect material for defects or damage prior to machining	EE	04.01.08	1																																																
5	MV	Machine as per Folio and Dwg D2671	EE	04.01.08	1																																																
6	QC2	Inspect parts as they come off the CNC machine	EE	04.01.08	1																																																
7	MV	Deburr	EE	04.01.08	1																																																
8	QC8 & 5	Second inspection	EE	04.01.09	1																																																
9	KP	Pick: Packing Kit (Note: D2671 is on the BOM as material from step 3) <table><thead><tr><th>Qty</th><th>Part Number</th><th>Description</th><th>Batch</th></tr></thead><tbody><tr><td>4</td><td>D2182B050</td><td>Rubber Cushion</td><td>B19540</td></tr><tr><td>8</td><td>D2274</td><td>Radius Block</td><td>B19922</td></tr><tr><td>2</td><td>D2671</td><td>Bearpaw</td><td>B19895</td></tr><tr><td>4</td><td>D2438</td><td>Clamp</td><td>B19615</td></tr><tr><td>8</td><td>D2529</td><td>Washer</td><td>B18930</td></tr><tr><td>8</td><td>AN4-15A</td><td>Bolt</td><td>M13437</td></tr><tr><td>8</td><td>AN4-17A</td><td>Bolt</td><td>M12642</td></tr><tr><td>16</td><td>AN960JD416</td><td>Washer</td><td>M13719</td></tr><tr><td>8</td><td>MS21042L4</td><td>Nut (or -4)</td><td>M13928</td></tr><tr><td>2</td><td>QS200M44S</td><td>Clamp</td><td>M13928</td></tr><tr><td>1</td><td colspan="3">Paperwork package from Step 2</td></tr></tbody></table>	Qty	Part Number	Description	Batch	4	D2182B050	Rubber Cushion	B19540	8	D2274	Radius Block	B19922	2	D2671	Bearpaw	B19895	4	D2438	Clamp	B19615	8	D2529	Washer	B18930	8	AN4-15A	Bolt	M13437	8	AN4-17A	Bolt	M12642	16	AN960JD416	Washer	M13719	8	MS21042L4	Nut (or -4)	M13928	2	QS200M44S	Clamp	M13928	1	Paperwork package from Step 2			ME	04/1/9	1
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1	Paperwork package from Step 2																																																				
10	QC4	Inspect Kit for 100% Completeness on the W/O	EE	04-01-09	1																																																
11	PK	Identify and pack for shipping as per PPP K10005	ME	04/1/09	1																																																
12	AC	Cost / part <u>231.13</u>	SAC	04-01-09	1																																																
13	DC	Close W/O <u>231.13</u> Inspect Level 21	HJ	04.01.09	1																																																

Rev	Date	Change	Revised By	Approved
A	99.12.17	K10005 created for Bearpaw Kit	EC	
B	03.05.28	Reformat; Incorporated D2671	KJ/RF	

RELEASED
03.06.10

Work Order:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Manuf / Design Mgr	Approval QC Inspector

NCR		WORK ORDER NON-CONFORMANCE						
DATE	STEP	Description of NC section A	Corrective Action Section B		Sign & Date	Verification Section C	Approval Design Mgr	Approval QC Inspector
			Initial					

PAR#: _____ Fault Category: _____ DQA: _____ Date: _____

NOTE: Date & initial all entries
H:\Admin-QA\ISO\forms\w\oncb.doc

QA: N/C Closed: _____ Date: _____

Job Costing Report

Dart Aerospace Ltd.
Hawkesbury

Nov 05, 2003
12:32 pm

Work Order No : 0019895
Project Name : *K10005
Project For : WK348
Work Order Type : Main
Main WO Number :
House Part Number : *K10005
Description : Bearpaw kit 13" x 16"
Manufactured : Yes
Amount Req'd :
Amount Done : 0
Start Date : 11-05-03
Est Finish Date : 11-27-03
Act Finish Date :
Drawings Req'd : No
Ok for Approval :
Approval Rec'd :

Department Code:
Burden Flags : NNNNNNNN
WO Status : Open
Invoice State : Not Invoiced
Invoice Date :
Invoice Number :
Invoice Amount : 0.00
Order Entry No :
OE Value : 0.00
Est Margin : 0.000%
Actual Margin : 0.000%
\$0 Posted to Finished Goods

	Estimated	Actual	Var. %	Posted	To Post
Material Cost	0.00	0.00	0.00	0.00	0.00
Engineering Hours	0.00	0.00	0.00		
Engineering Cost	0.00	0.00	0.00	0.00	0.00
Production Hours	0.00	0.00	0.00		
Production Cost	0.00	0.00	0.00	0.00	0.00
Packaging Hours	0.00	0.00	0.00		
Packaging Cost	0.00	0.00	0.00	0.00	0.00
OverHead Hours	0.00	0.00	0.00		
OverHead Cost	0.00	0.00	0.00	0.00	0.00
CNC Hours	0.00	0.00	0.00		
CNC	0.00	0.00	0.00	0.00	0.00
Misc. Hours	0.00	0.00	0.00		
Misc.	0.00	0.00	0.00	0.00	0.00
Burden	0.00	0.00	0.00		
Total Cost	0.00	0.00	0.00		
Margin	0.000	0.000			
Selling Cost	0.00	0.00			




	Estimated	Actual
Labour Hrs/Amount Done :	0.00	0.00
Profits/(Loss) :	0.00	0.00

DART AEROSPACE LTD		Work Order: 19895
Description:		Part Number: K10003D2671
Inspection Dwg: D2671 Rev: B1		Page 1 of 1

FIRST ARTICLE INSPECTION CHECKLIST

☒ First Article ☐ Prototype

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
0.375	±0.01	0.380	✓			
2.000	"	2.004	✓			
15.75	"	15.75	✓			
12.75	"	12.75	✓			
4.250	"	4.256	✓			
8.500	"	8.503	✓			
Ø.260	+0.005 -0.001	Ø.261	✓			
0.300	±0.01	0.295	✓			
0.625	"	0.631	✓			
0.250	"	0.256	✓			
0.200	"	0.198	✓			
5.500	"	5.508	✓			
0.950	"	0.957	✓			
0.375	"	0.381	✓			

Measured by: 	Audited by: 	Prototype Approval: 
Date: 07.01.08	Date: 04.01.08	Date: N/A

Rev	Date	Change	Revised by	Approved
A		New Issue	KJ/RF	